

Work Order ID 72649



Page 1

Wednesday, August 03, 2011 2:45:43 PM

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A
D4020	A

100 Weld per dwg A/R S.S. rod Batch: *M114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

PAB 11/08/12 Pl 11-08-12

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.08.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

8 w/08/12

(X)

H Ø m-1 11/08/16

W/O:		WORK ORDER CHANGES					
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Required Date:	8/12/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--



Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: XPM 21/08/16

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Handwritten: 23/08/17

Handwritten: M118439

Handwritten: 10:00 400 OF 10:35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Assemble as per dwg 0.00



HandFinish Memo 0.00

Hand Finishing Pick Kit

EP 11/08/17 @

160 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8 u102123

170 Identify as per dwg & Stock Location: *G-A* 0.00



Packaging Memo *w/o* 0.00

Packaging

72648 (12)

EP 11/08/17 @

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Required Date: 8/12/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11-08-24 

11-08-24 

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 72649

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00


Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC


IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	63.0000	2	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--


Location	Loc Qty	Loc Code
WA	63	
69258	28	
69739	2	
70766	33	

PM B 11/08/12

D3913-1  Rib		Manufactured	No			100	Each	8.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	8	
59089	1	
69260	2	
70346	2	
72086	3	

PM B 11/08/04

D3913-15  Wide Handle Plate		Manufactured	No			100	Each	13.0000	1	1			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	6	
69158	2	
69647	4	
WA005	7	
69012	1	
72550	6	

PM B 11/08/04

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each

5.0000

1

1



Rib



PMB 10/08/04

Location

Loc Qty

Loc Code

WA

1

69160

1

WA006

4

69646

2

71482

2

D3913-7 Manufactured No

100 Each

16.0000

2

2



Rib



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

8

69521

2

70334

6

WA006

8

65278

1

66435

1

72457

6

D3913-9 Manufactured No

100 Each

5.0000

1

1



Hinge Rib



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

2

70336

2

WA006

3

70138

1

71479

2

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Shop Packet Print

Page 2

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-041

Manufactured No

100

Each

10.0000

2

2



Rib Assembly



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

10

69161

2

71282

2

71994

6

D3916-5

Manufactured No

100

Each

16.0000

3

3



Light Rib



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

16

59088

3

69076

4

71938

9

D4016-1

Manufactured No

100

Each

31.0000

3

3



Hinge Half, Base



PMB 11/08/12

Location

Loc Qty

Loc Code

WA

31

66418

0

68426

3

70342

10

72009

18

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100 Each

6.0000

1

1



Rib



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

3

69730

1

71944

2

WA005

3

72008

3

D4017-9

Manufactured No

100 Each

12.0000

2

2



Rib



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

6

70341

2

71742

4

WA006

6

72007

6

D4020-11

Manufactured No

100 Each

12.0000

2

2



End Mesh, Basket



PMB 11/08/11

Location

Loc Qty

Loc Code

WA

12

69648

2

71725

4

72223

6

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Page 4

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Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100 Each

33.0000

3 3



Handle Plate



PAB 11/08/04

Location

Loc Qty

Loc Code

WA

33

69518

6

69777

27

D4034-041 Manufactured No

100 Each

6.0000

1 1



Aft Upper Rib Assembly



PAB 11/08/04

Location

Loc Qty

Loc Code

WA

5

71483

2

71972

3

WA006

1

69157

1

D4034-043 Manufactured No

100 Each

6.0000

1 1



Fwd Upper Rib Assembly



PAB 11/08/04

Location

Loc Qty

Loc Code

WA

2

71955

2

WA006

4

70241

1

72490

3

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

723.2433

33

33



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

MAT

11.5607

117708

11.5607

WA

711.6826

115012

95

117197

102.9036

117455

16.0341

117896

53.3264

118153

98.6394

118248

66.0983

118450

279.6808

AN3-10A

Purchased

No

150

Each

121.0000

6

6



Bolt

Location

Loc Qty

Loc Code

ST351

121

117313

5

117795

116

AN960JD8

NAS1149DN832J Purchased

No

150

Each

0.0000

2

2



Washer

D2931

Manufactured

No

150

Each

612.0000

2

2



Bumper

Location

Loc Qty

Loc Code

ST504

612

46064

612

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Page 6

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

8.0000

2

2



Blanking Plate



EP 11/08/17

Location

Loc Qty

Loc Code

GA

6

70349

6

WA005

2

67008

2

2

MS20600-AD4W3

Purchased

No

150 Each

843.0000

2

2



Cherry Rivets



EP 11/08/17

Location

Loc Qty

Loc Code

ST321

710

111636

112

117505

450

117601

148

WA018

133

107939

133

2

MS21042L3

Purchased

No

150 Each

2,185.000

6

6



Nut



EP 11/08/17

Location

Loc Qty

Loc Code

ST300

2185

117441

437

117601

400

117885

348

118451

1000

6

W/O:		WORK ORDER CHANGES					
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Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

256.0000

12

12



WASHER

EP 11/08/17

Location

Loc Qty

Loc Code

ST275

256

117735

87

118354

166

17317

3

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

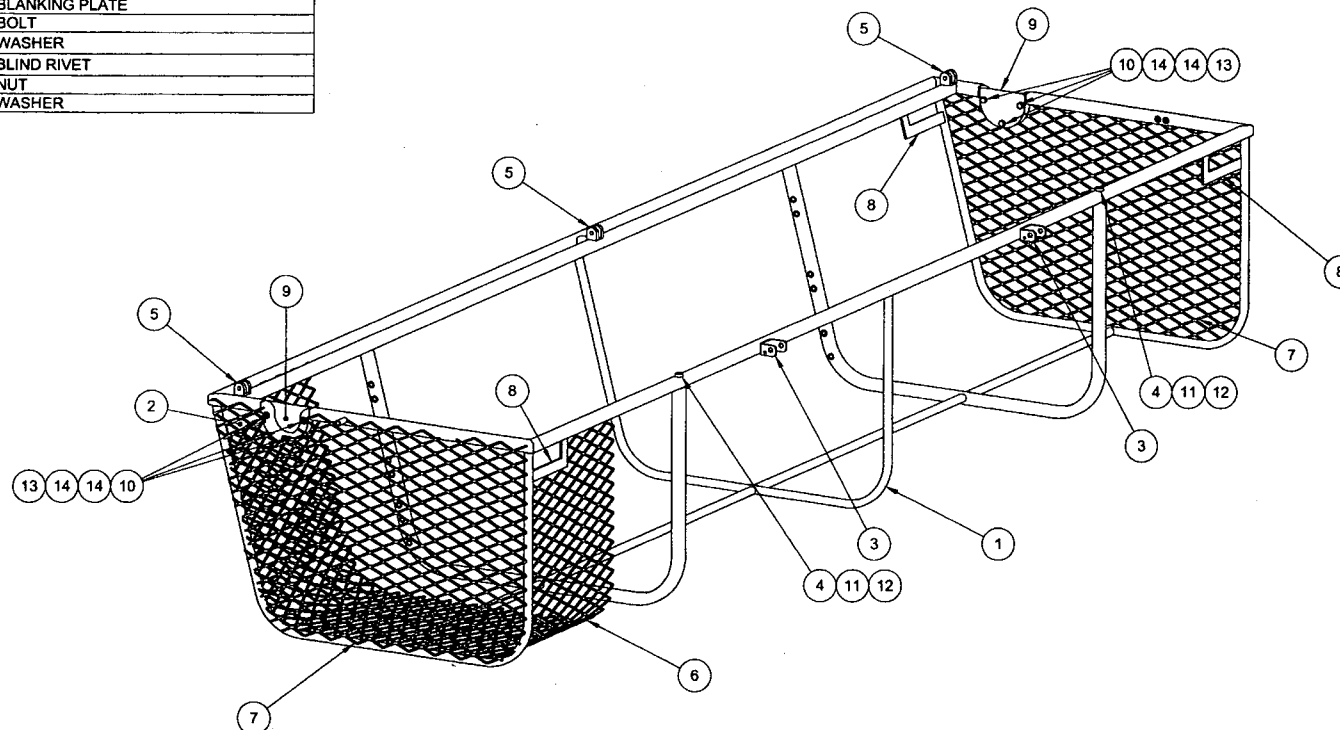
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3913	SHEET 1 OF 6
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D8-2
D4020-1
MESH

D3913-101
TUBULAR ASSY

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL [8]

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
3 PL

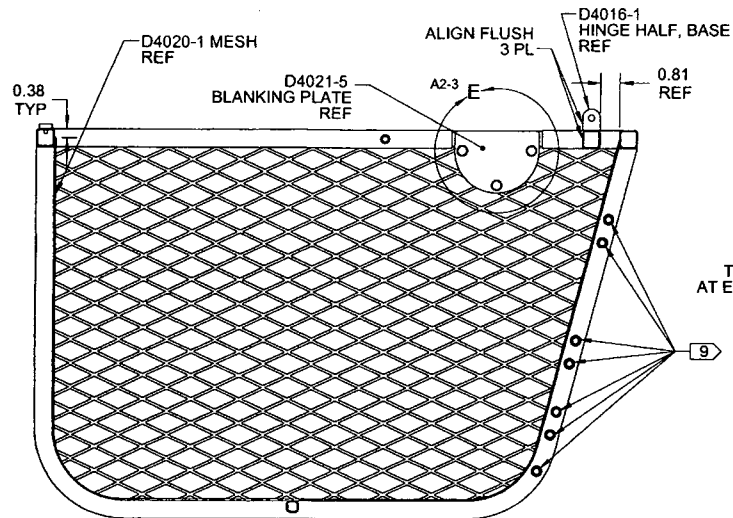
D4021-1
HANDLE PLATE

D4021-1
HANDLE PLATE
2 PL

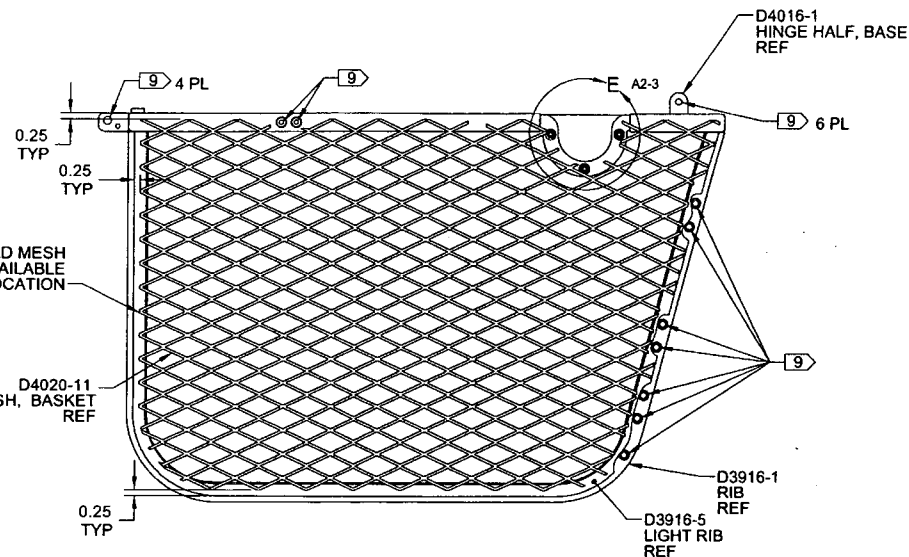
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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2010-03-16

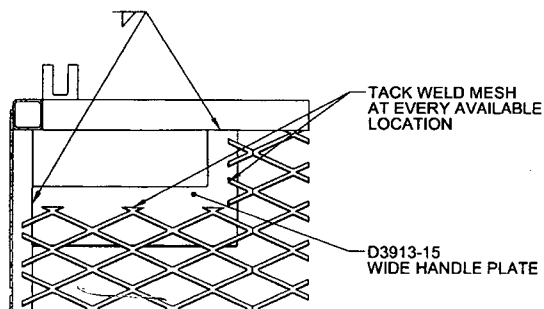
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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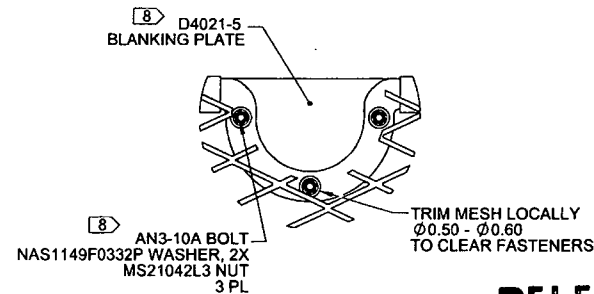
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



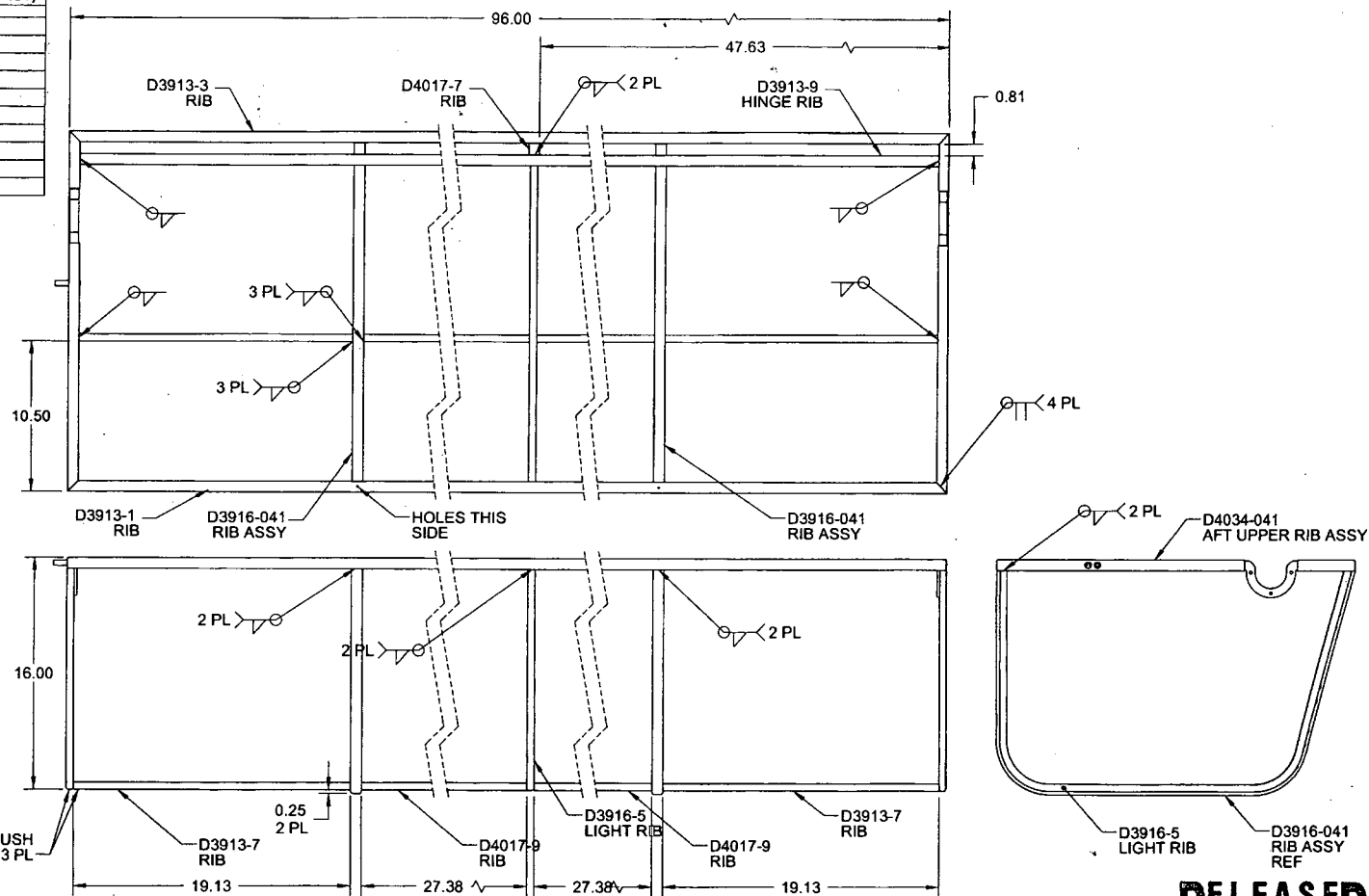
DETAIL D2-3
D6-3

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72649

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

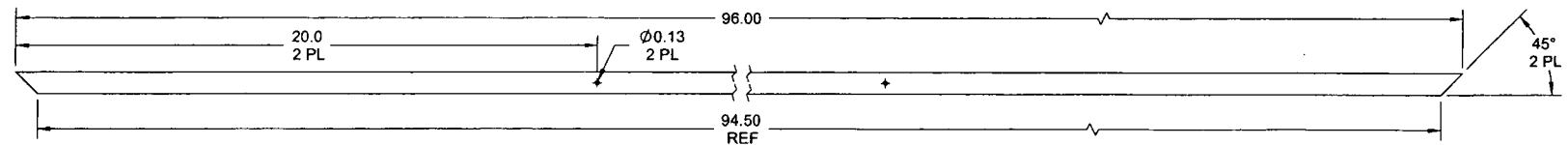


8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

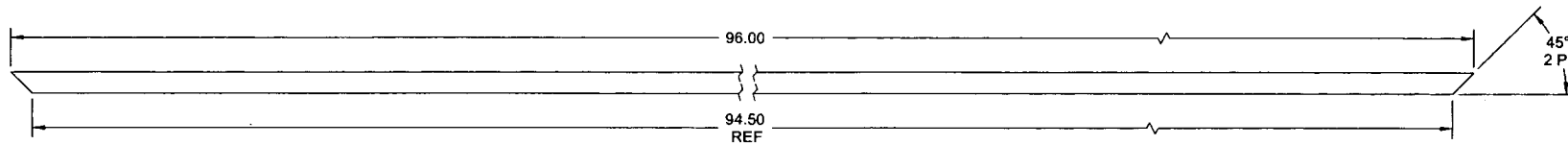
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

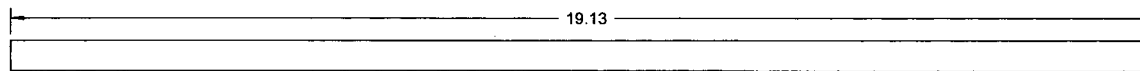
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	
DE APPR.		LONG BASKET BASE ASSY (350)	
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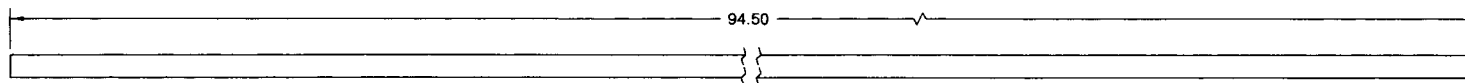
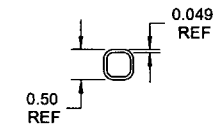
D3913-1 RIB



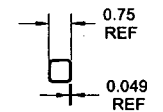
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

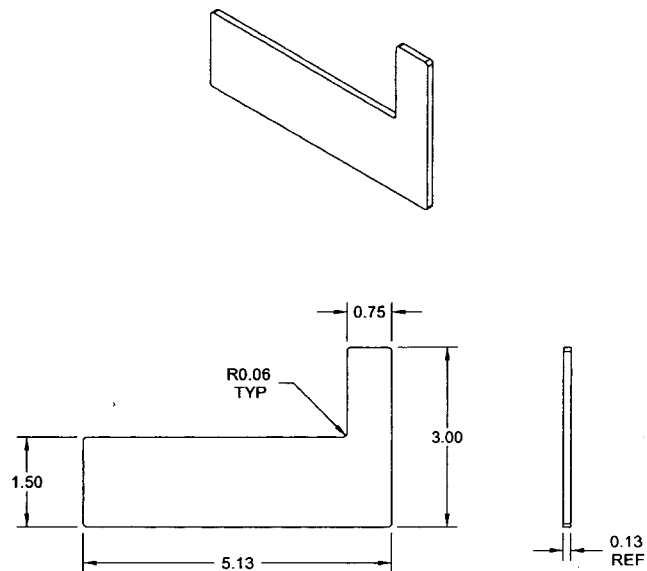
-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

Handwritten signature/initials

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2010-03-22

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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R 2010-03-22

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MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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